

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008280**Date Inspected:** 01-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

3AE

SMAW repair welding of weld joint 004 located on SSD17A-PP021.

Welder is identified as Mr. Zhu Ming Song (204339). ZPMC QC is identified as Mr. Xu Yu Ming.

The welding variables recorded by QC appeared to comply with WPS-SMAW-345-2G (2F)-Repair and CWR procedure B-CWR629.

3AW

SMAW repair welding of weld joints 003 and 004 located on SSD10-PP020.

Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Mr. Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-SMAW-345-2G (2F)-Repair and CWR procedure B-CWR617.

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4BW

SMAW repair welding of weld joint 100 located on SEG019B.

Welder is identified as Mr. Li Bo (050433). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

CB2

SMAW repair welding of bottom plate stiffeners on 3AW connection side.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Mr. Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair.

1AAW & 1AW

This QA Inspector and QA Inspector Manikandan Murugan, performed the dimensional verification of bottom, side and deck panel I ribs on 1AAW and 1AW segments.

1AAW

QA Inspector witness the removal of fillet weld on floor beam located at Panel Point 8.5. Weldment was completely removed due to alignment issues. Noted work started at 1035, completed at approximately 1635 and was performed per WRR procedure B-WR6634.

NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trail assembly yard. Locations are as followed:

1. Side Plate mounting brackets at panel point on Segment 4AW (crossbeam side).
2. Bottom Plate stiffeners on CB2 (3AW connection side).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
